



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT18538-3
Job Sheet 189093



Part No: RBT18538-3

Job Qty: 20 ea

Part Name: Right Seat Brace



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/18/19

Job Tracking No:

Due Date: 2/15/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBT18538 Rev2A IPP Rev A 17.12.13 New issue DP verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sig-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	20 pcs	2/15/19	2/15/19	0.00	2.00	Waterjet - Flow		OC 19/01/31
110	QC	20 pcs	2/15/19	2/15/19	0.00	0.00	QC2 Waterjet-4		OC 19/01/31
120	QC	20 pcs	2/15/19	2/15/19	0.00	0.00	QC8-7		5C 19/02/2
130	Brake NC	20 pcs	2/15/19	2/15/19	0.00	5.00	Brake NC 1		58 19/03/05
140	QC	20 pcs	2/15/19	2/15/19	0.00	0.00	QC5		9 19/03/05
150	Outsource	20 pcs	2/15/19	2/15/19			ATG001-VC	5	41 19/03/05
160	Packaging	20 pcs	2/15/19	2/15/19	0.00	0.00	Packaging2		DP 19/03/05
170	QC	20 pcs	2/15/19	2/15/19	0.00	0.00	QC6		DP 19/03/05
180	Packaging	20 pcs	2/15/19	2/15/19	0.00	0.00	Packaging3-1		28 19/03/05
190	QC21-SA	20 Ea	2/15/19	2/15/19	0.00	0.00	QC21		9-89 19/03/05

Part Op 100 - 1-Cut as per Dwg (RED BARN FOLDER) Dwg Rev: 2A Prog Rev: 2A 2-Deburr if necessary

Descriptions: 130 - Form as per DWG sheet 2

140 - Engrave T/N And / or S/N number as required Using Marktronic engraver as per DWG.

150 - Issue P/O to ATG: -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS, Water sealant -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M5052H32S.040	5052-H32 .040 Sheet	7.2000 sf (.36 ea)	100-Waterjet - Flow - 1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M5052H32S.040	7	19	0

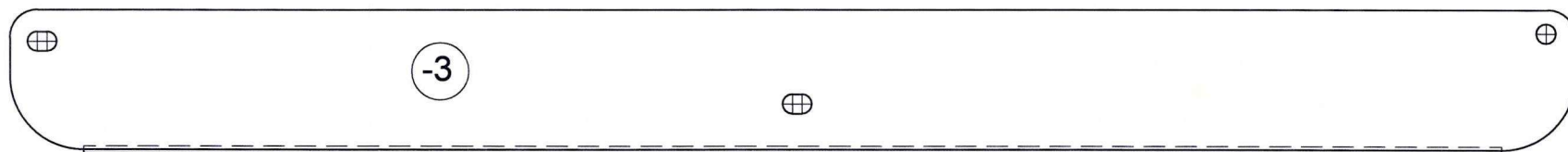
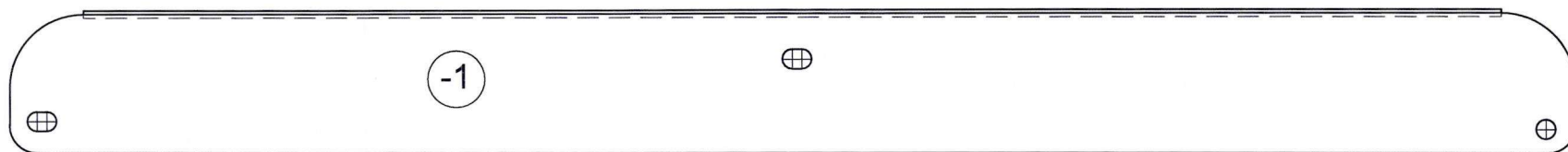
Part Specifications

Specifications could not be found.

Plex 1/18/19 10:19 AM Dart.lajeunesse.marie

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	ORIGINAL TOOL WAS A MACHINED SOLID PART, NOW A FORMED PART.	10/7/10	WP	
2	CH'D MATERIAL THICKNESS FROM .06 TO .04, CH'D CUT OUTS ON END FROM .75 TO .83 (x2), CH'D R.31 (x4) TO R.31 (x2), & ADDED R.83 (x2), CH'D TWO Ø.218 HOLES TO ELONGATED SLOTS, ADDED R.125 (x2) TO LIP PER D.W.	1/6/11	RJC	
2A	ADDED ENGRAVE NOTE -1 & -3 PER R.W.	2/17/11	RJC	RW



Added B & L & 407 to used on
model 3/20/12 after DW veified
the hole pattern is the same.
No rev done. RJC

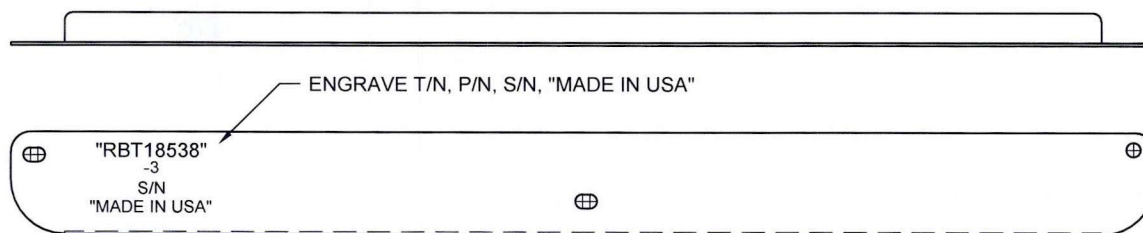
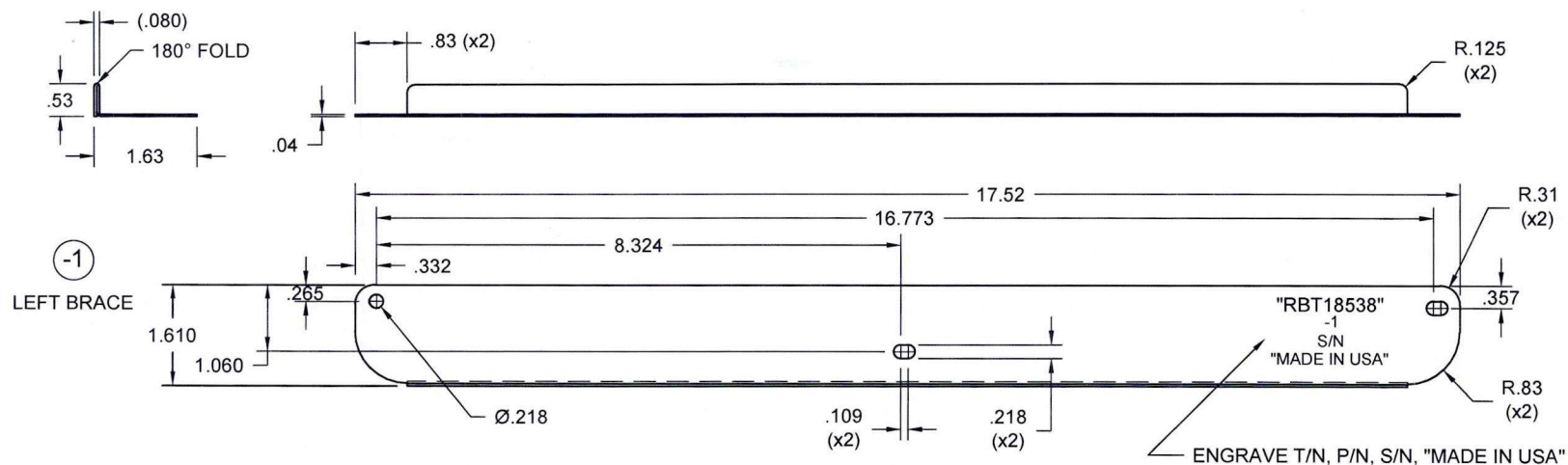
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 189093 MWS
190178

 RED BARN MACHINE	
TITLE SEAT FRAME SUPPORTS	
DWG NO. RBT18538	REV 2A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 METRIC REF. XXmm ± .1mm .XX ± .01 FRACTIONS ± 1/32 .X ± .1 ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 10-7-10
SHEET 1 of 2	

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
			-1	1	LEFT SEAT BRACE	5052	.040 x 2-3/4 x 17-5/8	2
			-3	1	RIGHT SEAT BRACE	5052	.040 x 2-3/4 x 17-5/8	2

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
2	CH'D MATERIAL THICKNESS FROM .06 TO .04, CH'D CUT OUTS ON END FROM .75 TO .83 (x2), CH'D R.31 (x4) TO R.31 (x2), & ADDED R.83 (x2), CH'D TWO Ø.218 HOLES TO ELONGATED SLOTS, ADDED R.125 (x2) TO LIP PER D.W.	1/6/11	RJC
2A	ADDED ENGRAVE NOTE -1 & -3 PER R.W.	2/17/11	RJC



-3
RIGHT BRACE
(DIMENSIONALLY OPPOSITE LEFT BRACE)

RED BARN MACHINE	
TITLE SEAT FRAME SUPPORTS	
DWG NO. RBT18538	REV 2A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	
METRIC REF. XXmm ± .1mm FRACTIONS ± 1/32 ANGLES ± .5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 015 x 45° PR .015 R 2 DIMENSIONAL LIMITS APPLY AFTER PLATING	
DRAWN BY: PERRITT	
APPROVED: <i>D. Weil</i>	
HEAT TREAT: CLEAR ANODIZE	
FINISH: CLEAR ANODIZE	
SPEC: MIL-A-8625F, TYPE II, CLASS I	
USED ON MODEL: BELL 206 B & L, 407	
SCALE: NTS	DATE: 10-7-10
SHEET: 2 of 2	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S150044



Part: RBT18538-3

Job No: 189093

Serial No/Batch: S150044

Revision: 2A

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 01/31/19



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042839



Supplier: ATG001-VC
A.T.G. Industries Inc
760 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO042839

PO Date: 3/8/19

Due Date: 3/15/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	191260	HT-900-NC-09A	Filter Base Outsource4 (Outsource process- Anodize per QSI017 4.1.10.1) -Issue P/O to GROUPE ALTECH PO: -ANODIZE COLOR BLACK, PER IAW MIL-A- 8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed X4	-	3/15/19	4 pcs	0 pcs	4 pcs	\$3.72/pcs	\$14.88

MAR 14 2019

DP

Line Item Note **Need back for March 15,2019**



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PURCHASE ORDER

PO042839



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	189092	RBT18538-1	Left Seat Brace -Issue P/O to ATG: -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required	Firmed -		3/15/19	21 pcs	0 pcs	21 pcs	\$3.72/pcs	\$78.12
Line Item Note **Need back for March 15,2019**											
3	186665	RBT18538-3	Right Seat Brace -Issue P/O to ATG: -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required	Firmed -		3/15/19	10 pcs	0 pcs	10 pcs	\$3.72/pcs	\$37.20
Line Item Note **Need back for March 15,2019**											
4	189093	RBT18538-3	Right Seat Brace -Issue P/O to ATG: -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required	Firmed -		3/15/19	9 pcs	0 pcs	9 pcs	\$3.72/pcs	\$33.48
Line Item Note **Need back for March 15,2019**											



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PURCHASE ORDER
PO042839



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5	R190195	C2-1-1	Manual Release Knob (Outsource process- Anodize per QSI017 4.1.10.1)-Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	-	3/15/19	5 pcs	0 pcs	5 pcs	\$3.72/pcs	\$18.60
Line Item Note **Need back for March 15,2019**											
6	R190194	4.5NR-32	Manual Release Knob RED ANODIZE PER MIL-A-8625 TY II CL 2	Firmed	-	3/15/19	22 pcs	0 pcs	22 pcs	\$3.72/pcs	\$81.84
Line Item Note **Need back for March 15,2019**											
7	186714	646.3012	Lower Guide Issue P/O to ATG : Hard Anodize, Color Black and Prime as per Dwg 646.3000	Firmed	-	3/15/19	4 pcs	0 pcs	4 pcs	\$21.32/pcs	\$85.28
Line Item Note **Need back for March 15,2019**											
8	187494	646.3012	Lower Guide Issue P/O to ATG : Hard Anodize, Color Black and Prime as per Dwg 646.3000	Firmed	-	3/15/19	8 pcs	0 pcs	8 pcs	\$21.32/pcs	\$170.56
Line Item Note **Need back for March 15,2019**											



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PURCHASE ORDER

PO042839



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
9	190533	RBW109-3130-34-1-1	Cylinder, Ø2-5/8 X 4-1/2 -Issue P/O; -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	3/15/19	5 pcs	0 pcs	5 pcs	\$3.72/pcs	\$18.60

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Line Item Note **Need back for March 15,2019**

Grand Total: \$538.56

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 3/14/19 3:07 PM dart.Lussier.Patrick



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 917447

Date: 14-Mar-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
each	Part: HT-900-NC-09A Filter Base Anodize per MIL-A-8625F, Type II, Class 2, Black, Water Sealant .0004-.0010" (.4 - 1 mils). Job: 24753	Rev: 6E PO: PO042839	Line: 1
21 ea	Part: RBT18538-4 Left Seat Brace Clear Anodize per MIL-A-8625F, Type II, Class 1, Clear .0004-.0010" (.4 - 1 mils), Water Sealant Job: 24754	Rev: 2A PO: PO042839	Line: 2
19 ea	Part: RBT18538-3 Right Seat Brace Clear Anodize per MIL-A-8625F, Type II, Class 1, Clear .0004-.0010" (.4 - 1 mils), Water Sealant Job: 24755	Rev: 2A PO: PO042839	Line: 3-4
5 each	Part: C2-1-1 Manual Release Knob Anodize per MIL-A-8625F, Type II, Class 2, Red, .0004-.0010" (.4 - 1 mils) Water Sealant Job: 24756	Rev: PO: PO042839	Line: 5
22 each	Part: 4.5NR-32 Manual Release Knob Anodize per MIL-A-8625F, Type II, Class 2, Red, .0004-.0010" (.4 - 1 mils) Water Sealant Job: 24757	Rev: 1 PO: PO042839	Line: 6
5 ea	Part: RBW109-3130-34-1-1 Cylinder, Ø2-5/8 x 4-1/2	Rev:	

Made in Canada.



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 917447

Date: 14-Mar-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Anodize per MIL-A-8625F, Type II, Class 1, Clear, .0004-.0010" (4 - 1 mils) Job: 24759 PO: PO042839 Line: 9		
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>14/3/19</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			